

Work Order ID 87427

July-11-12 11:37:38 AM

ASAD
87427

Page 1

Item ID: D3694-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: MOUNTING PLATE
 Start Date: 7/10/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/10/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3694	Rev C

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Install helicoils as per Dwg D36942-Install Protective & Mounting plate as per Dwg D3694								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location <i>ST255</i>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

JP 12/07/12

DAS 16 12/07/13

SP 12-7-B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: MOUNTING PLATE
Start Date: 7/10/12 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/10/12 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

CK 12/7/13
MF
12-07-13

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 87427

Parent Item: D3694-041

Start Date: 7/10/12

Required Date: 7/10/12

Parent Item Name: MOUNTING PLATE

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM
IPP Rev:B 09-01-13 As per Rev C JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R8 Screw		Purchased	No				Each	548.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST348		548							
				9216		548							
AN960JD10 Washer	NAS1149D0363J	Purchased	No				Each	0.0000		10		7/12/07/12	
D3694-1 Mounting Plate		Manufactured	No				Each	1.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST255		1							
				56906		1							
D3694-3 MOUNTING PLATE ASSY		Manufactured	No				Each	7.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST255		7							
				56907		7							
D3694-5 MOUNTING PLATE ASSY		Manufactured	No				Each	8.0000		2		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST255		8							
				56908		8							

Dart Aerospace Ltd

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Picklist Print

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Page 2

Work Order ID: 87427

Parent Item: D3694-041

Parent Item Name: MOUNTING PLATE

Start Date: 7/10/12

Required Date: 7/10/12

Start Qty: 2.00

Required Qty: 2.00

MS21042L3 Purchased No Each 3,199.0000

8

Nut

Location Loc Qty Loc Code

ST300 1199

117885 32

119017 763

119075 138

121444 266

ST317 2000

122141 2000

MS21209-F120

Purchased No

Each 125.0000

4

HELI COIL

Location Loc Qty Loc Code

ST304 125

114037 29

121709 96

MS24693-C271

Purchased No

Each 5,529.0000

2

Screw

Location Loc Qty Loc Code

ST310 5529

1112 3735

1139 1183

1445 383

1664 228

MS24693-C273

Purchased No

Each 53.0000

8

Screw

Location Loc Qty Loc Code

ST310 53

120308 25

121060 28

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Shop Packet Print

Page 2

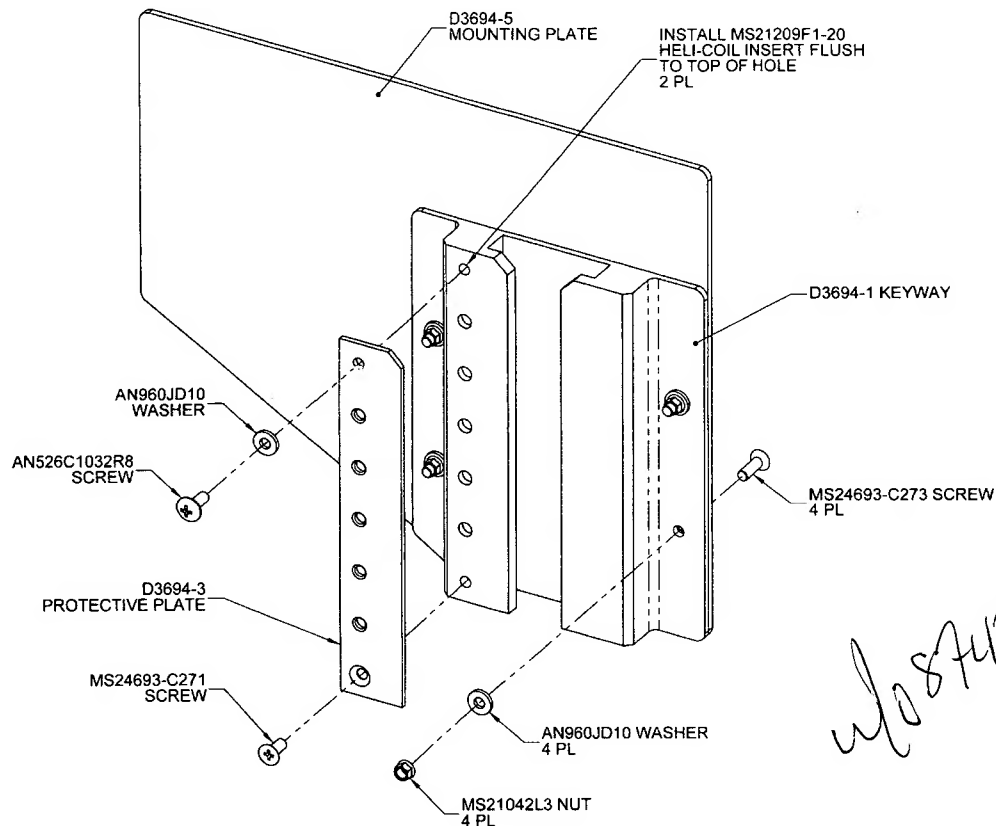
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D3694-041 MOUNTING PLATE ASSY

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

C	REDESIGNED ITEM 11; REVISED ITEM 12; DIM Ø 0.204 WAS Ø 0.234 (ZN D6-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1); REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY: 1 MS24693-C271 SCREW WAS QTY: 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3); REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

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RELEASED
09/12/05/MB

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3694** REV. C
SHEET 1 OF 4

TITLE **MOUNTING PLATE ASSY** SCALE NTS

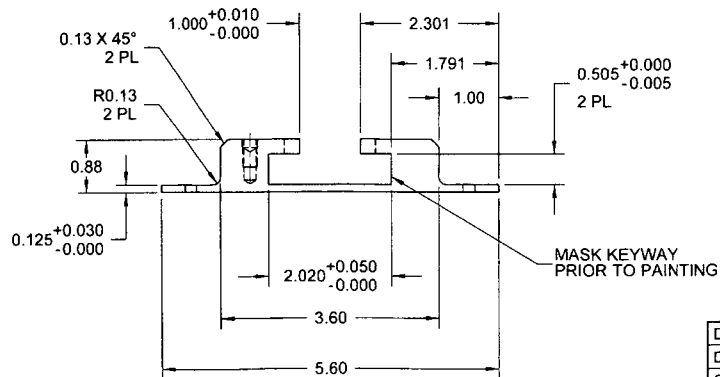
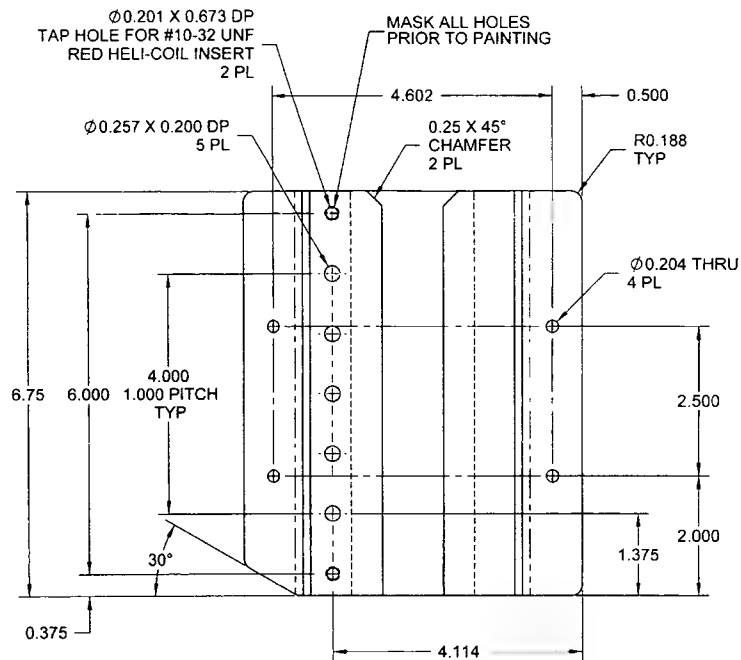
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NOTE: Date & initial all entries



D3694-1 KEYWAY

D3694-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

RELEASED
09/04/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG. APPR		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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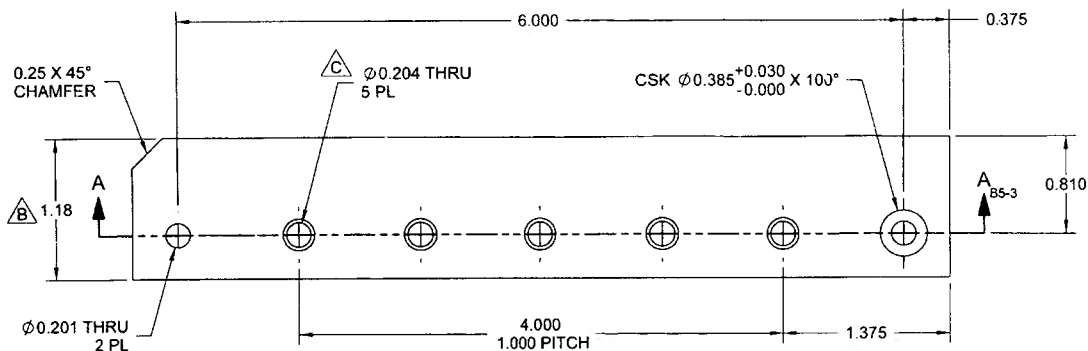
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

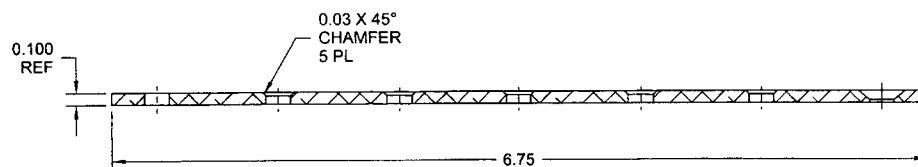
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NOTE: Date & initial all entries



D3694-3 PROTECTIVE PLATE



SECTION A-A

RELEASED
07/2/05

D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.			SHEET 3 OF 4
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DE APPR.			NTS
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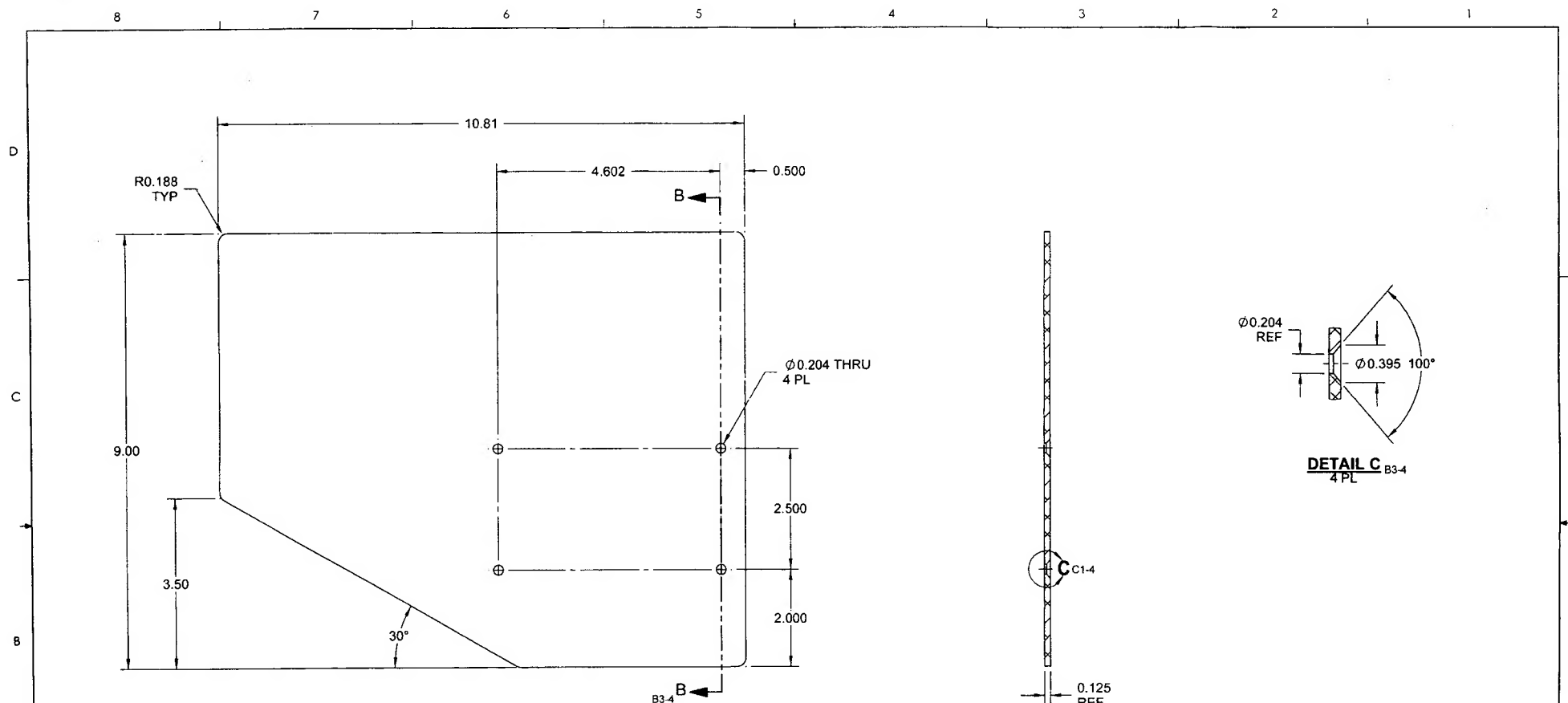
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D3694-5 MOUNTING PLATE

SECTION B-B B5-4

RELEASED
09/21/05

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3694	REV. C
MFG. APPR.		SHEET 4 OF 4	
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